

Date: Thursday, 19/06/2008 2:33:34 PM
User: Julie Lecocq

Process Sheet

Split up
SB 08/07/08

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MIRROR BRACKET RH
Job Number	: 39961 -1		
Estimate Number	: 12340		
P.O. Number	:	Part Number	: D20134 -1
This Issue	: 19/06/2008 S.O. No. :	Drawing Number	: D2013 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 36908	Material	:
Written By	:	Due Date	: 04/07/2008 Qty: 60 Um: Each
Checked & Approved By	: <u>JUL 08. 6.19</u>		
Comment	: Est Rev:A New Issue 05-11-01 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 2.0447 f(s)/Unit Total: 20.4467 f(s)
Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
(M304TR0.750W.049)
Batch: M 107688

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch as per template D2013-T3 and Dwg D2013

2-Flatten ends of D2013-3 tube as per Dwg D2013 using DT8545

3-Bend (1) tube as per Dwg D2013 using Jig DT8201
Identify as D2013-3.

4-Deburr as required

SB 08/06/24
EB 08/06/26 (10)

FF 08-07-10 (6)

EB 08/06/26 (10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/07/10 (x6)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5C 241

AS 08/07/10 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/06/2008 2:33:34 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET RH

Job Number: 39961

Part Number: D20134

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/10 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

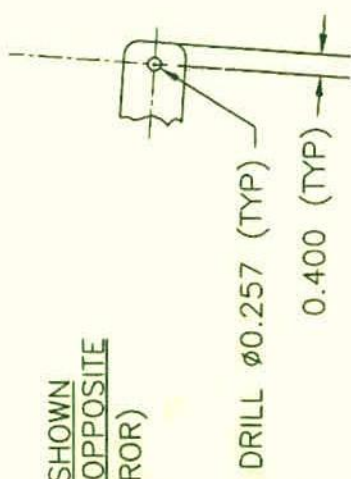
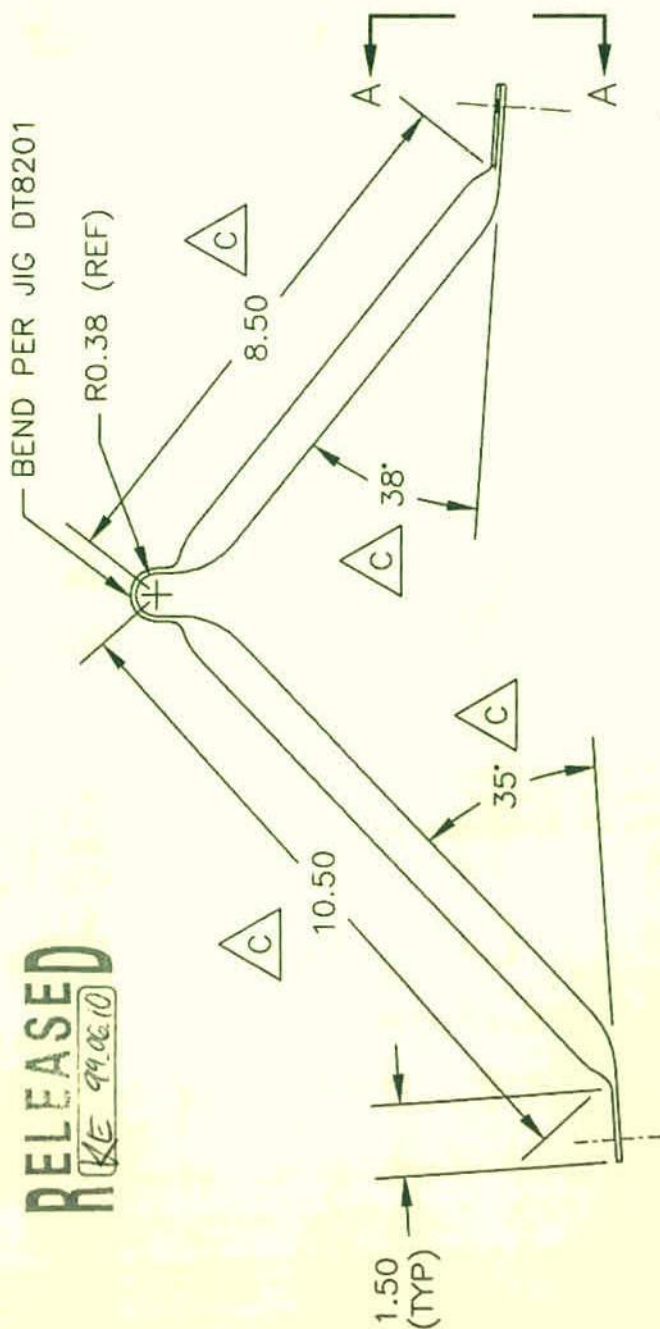
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN JB		DRAWN BY RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE		APPROVED JS		DRAWING NO. D2013	REV. C SHEET 1 OF 3
DATE 99.06.07				TITLE MIRROR BRACKET	SCALE NTS
A	90.10.22		NEW ISSUE		
B	94.06.15		REDRAWN		
C	99.06.07		REDRAWN, CHANGE OF DIMENSIONS		

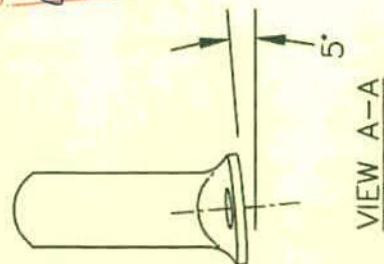


D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39961

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL



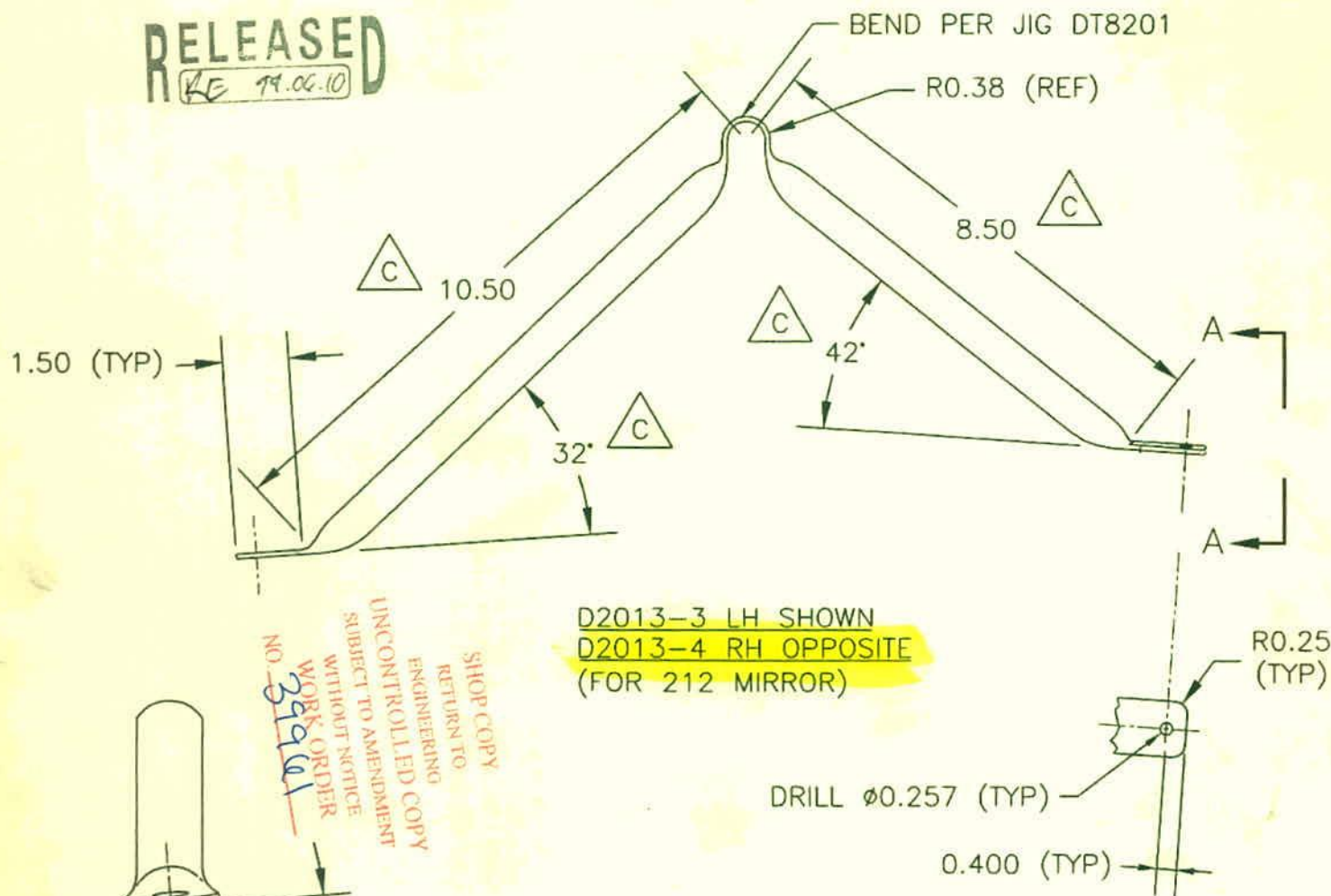
RELEASED
KE 99.06.10

RELEASED
KE 79.06.10

DART



DESIGN	CHECKED	APPROVED	DRAWING NO.	REV. C
JB	KE	RF	D2013	SHEET 2 OF 3
DATE	99.06.07	TITLE	MIRROR BRACKET	SCALE
				NTS



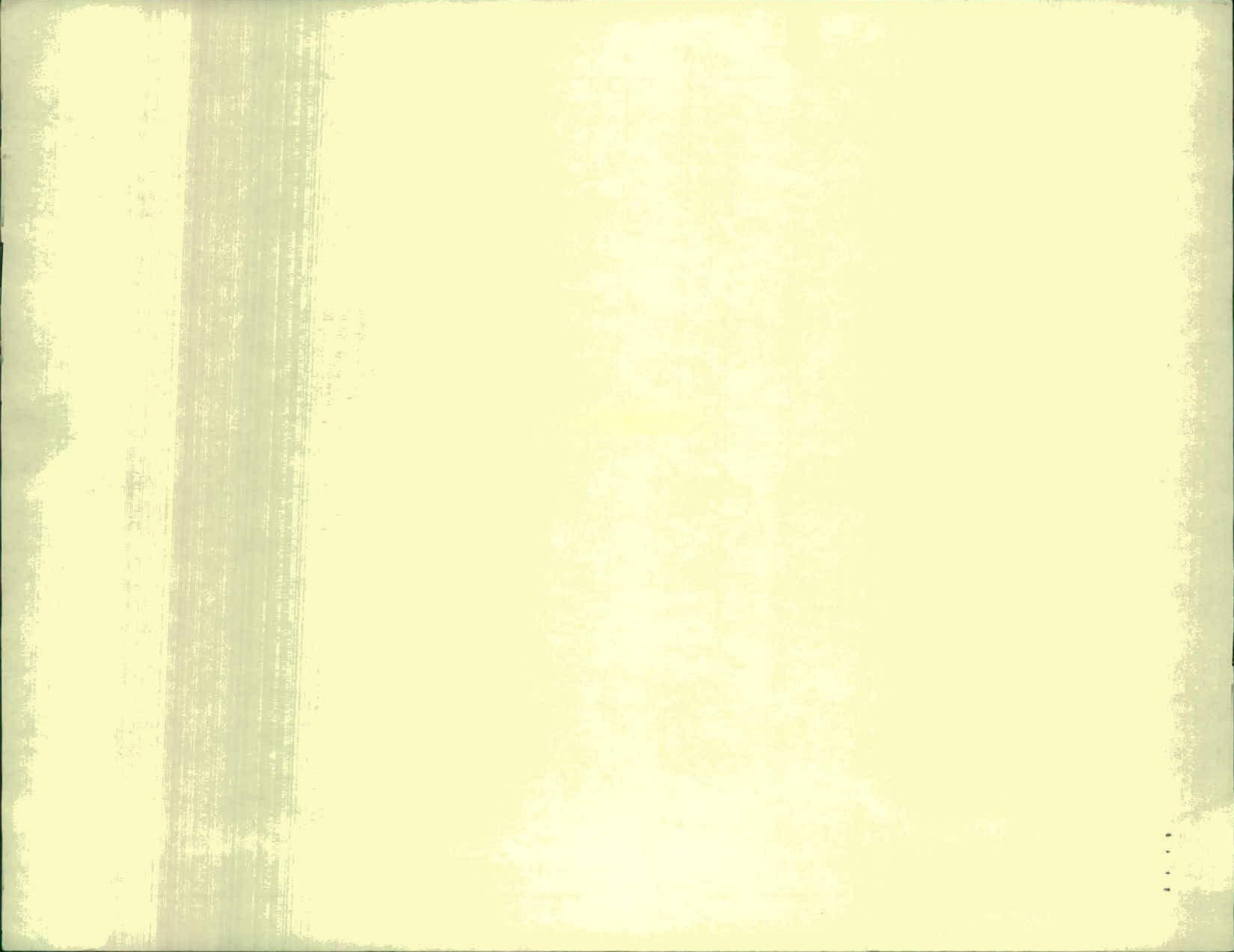
D2013-3 LH SHOWN
D2013-4 RH OPPOSITE
(FOR 212 MIRROR)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 34961
WORK ORDER

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

VIEW A-A



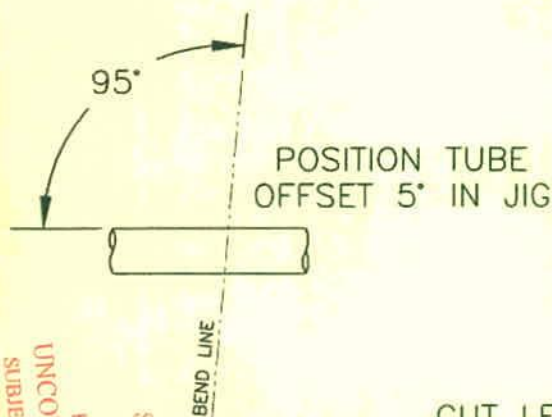
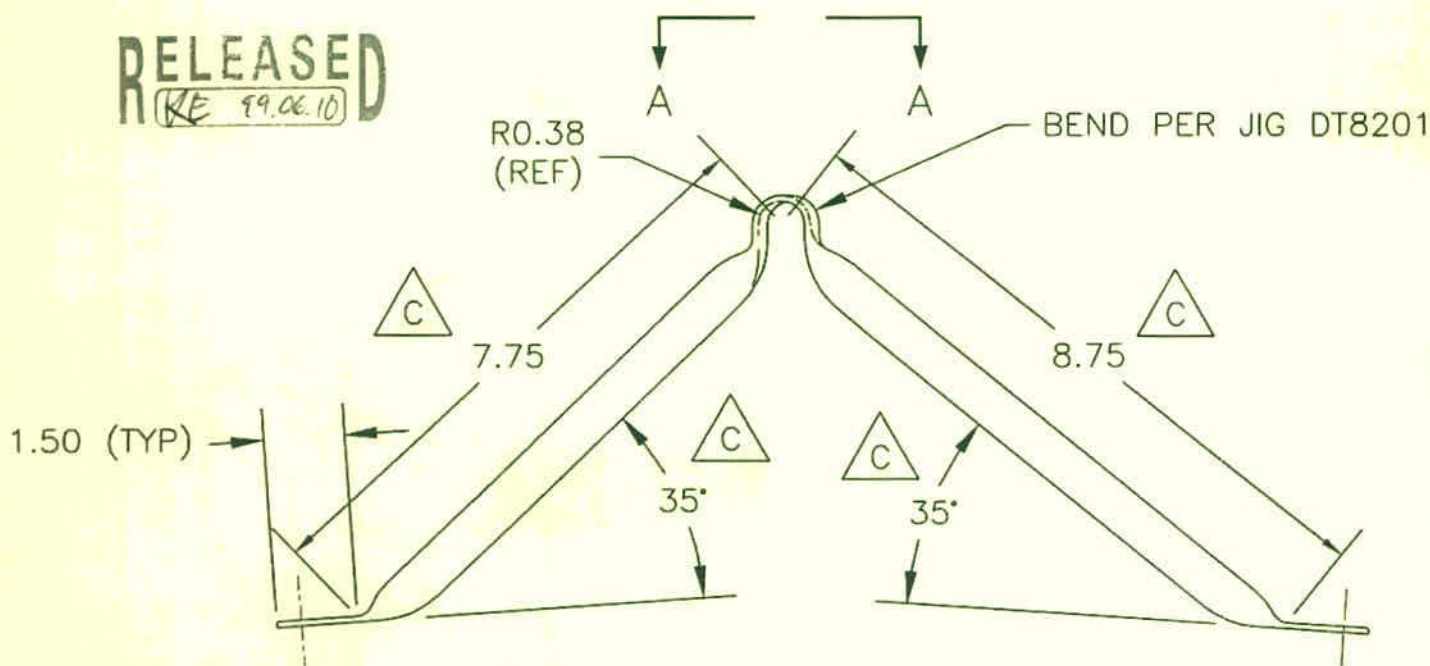
RELEASED
(KE 99.06.10)

DART

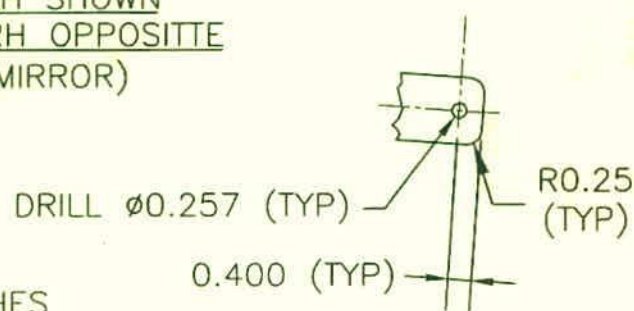


DESIGN	JB	DRAWN BY	RE	DRAWING NO.	D2013	REV. C
CHECKED	KE	APPROVED	RE	TITLE	MIRROR BRACKET	SHEET 3 OF 3
DATE	99.06.07					SCALE
						NTS

DART AEROSPACE LTD
HAMKESBURY, ONTARIO, CANADA



D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)



CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

VIEW A-A

NO. 32461
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
COPY
SHO
NO.

